

Date: 6/23/2006 7:38AM
User: Kim Johnston

PROCESS SHEET

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STROBE POWER SUPPLY RELOCAT
Job No.	: 27672	Part No.	: DSI9279011
Estimate No.	: 12033	Drawing No.	: D3246 REV A1
P.O. No.	: <u>N/A</u> SO No. <u>N/A</u>	Drawing Rev.	: A1
First Issue	: <u>N/A</u>	Project No.	: N/A
Prsht Rev.	: NC Type : SMALL /MED FAB	Material	: <u>N/A</u>
This Issue	: 6/23/2006	Due Date	: 6/29/2006 QTY: <u>103</u>
Prev. Run	: 27670		

Written by:











Checked & Approved by: JA De. 06.23

Comment :

Est. B 04.06.16 Changed rivet & added c'sink KJ/RF
Est Rev:C Now On Waterjet 06-06-22 JLM

Job Number:



Seq. No.	Machine or Operation	Description								
1.0	DC	DOCUMENT CONTROL								
										
	Comment: DOCUMENT CONTROL Issue Traveler Note: To be made in multiples of 5 Photocopy bluefile and create labels as per PPP DSI 9279-011 CHG001 KS 06.06.25									
2.0	PACKAGING 1	PACKAGING RESOURCE #1								
										
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit									
3.0	D3246041	Mounting Bracket								
										
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 3 4.0000 Each(s) Mounting Bracket Pick: Packing Kit (Note: D3246-1 is on BOM as material from Step 3)									
	<table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3246-041</td><td>Mounting Bracket Assy</td><td>B27670 i 3mlp</td></tr></table>	Qty	Part Number	Description	Batch	1	D3246-041	Mounting Bracket Assy	B27670 i 3mlp	
Qty	Part Number	Description	Batch							
1	D3246-041	Mounting Bracket Assy	B27670 i 3mlp							
4.0	AN960JD10	Washer								
										
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Washer Pick : Packing Kit Qty Part Number Description Batch 4 AN960JD10 Washer M100743									
5.0	MS27039107	Screw								
										

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/10/03

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Number:



Seq. No.	Machine or Operation	Description
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Screw Pick: Packing Kit Qty Part Number Description Batch 4 MS27039-1-07 Screw	2/2 ✓ M11660 2mcp-M/18057 ✓ 10m17
6.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
		06/10/02 (3) B06/10/02 (3)
	Comment: INSPECT 100% KITS FOR COMPLETENESS	
7.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP DSI 9279-011	Rev A B04/10/02 (3)
8.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	06/10/03 (3)

Job Completion



W 06.10.03

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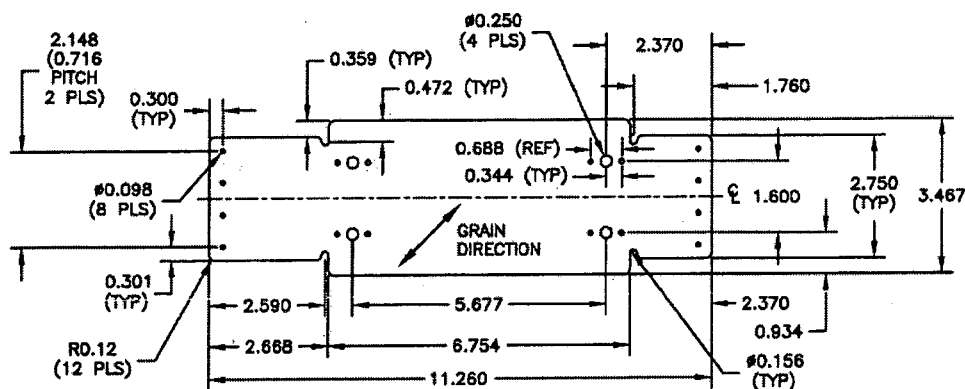
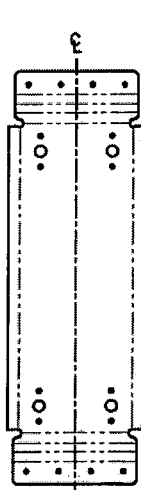
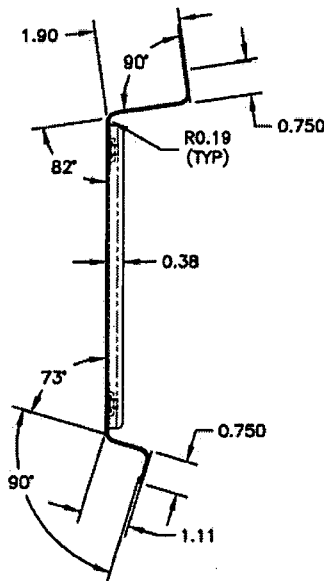
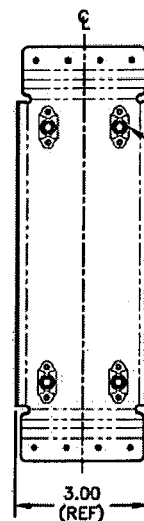
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21		TITLE MOUNTING BRACKET	SCALE 1:4
A	04.04.21	NEW ISSUE	
AI	04.06.16	CHANGE RIVET; ADDED C'SINK	

RELEASED
04.05.07 **D3248-1 FLAT PATTERN****D3246-1 BEND DETAIL****D3246-041 ASSEMBLY**

MS21059-L3
NUT PLATE (1)
MS20470AD3-4 RIVET (2)
(4 PLACES)
INSTALL AFTER
ALODINE
C'SINK $\phi 0.185 \times 100^\circ$
MS20426AD3-3 RIVET (2)

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S-050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

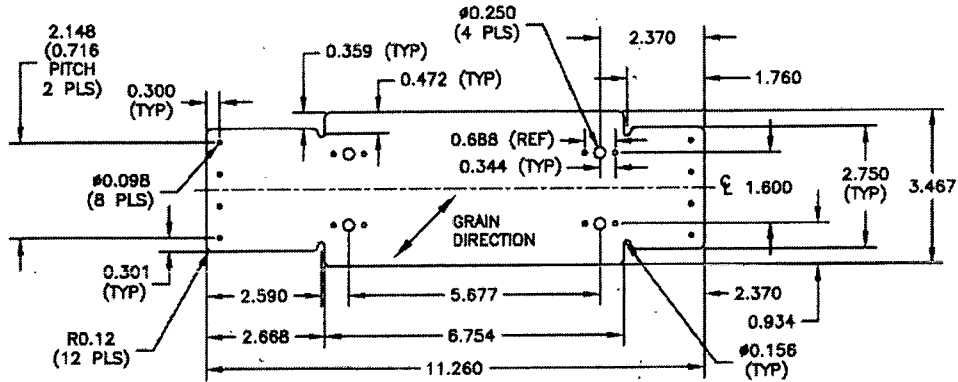
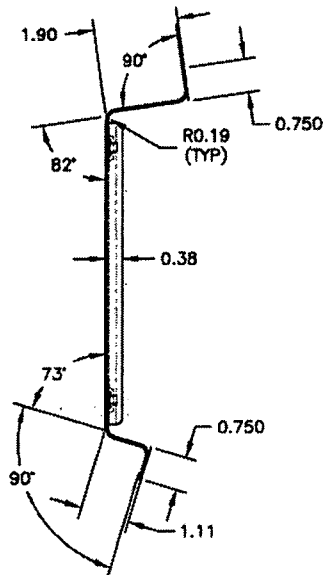
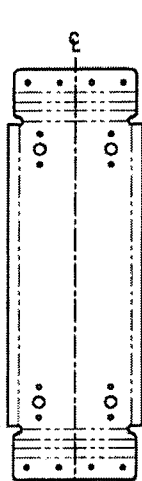
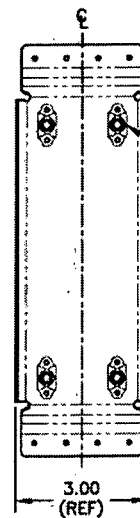
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DART

DESIGN JT	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21		TITLE MOUNTING BRACKET	SCALE 1:4
A	04.04.21	NEW ISSUE	
A1	04.06.16	CHANGE RIVET; ADDED C SINK	

RELEASED
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- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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